

Date: Thursday, 20/11/2008 3:11:23 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LH ACTUATOR ASSEBLY		
Job Number	: 43569					
Estimate Number	: 12761					
P.O. Number	:			Part Number	: 41232 200 001 001	
This Issue	: 20/11/2008		S.O. No.	: 41232-200-001 REV IR		
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	: 43286			Drawing Revision	: IR	
Written By	:			Material	:	
Checked & Approved By	: <u>JUL 08-11-21</u>			Due Date	: 28/12/2008	
Comment	: Est Rev:A New Issue 07-02-28 JLM			Qty:	2	Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:		
1.0	MS208224	elbow		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)		
		elbow	<u>M110363</u>	<u>9/5/21</u>
		Batch:		<u>SCD</u>
2.0	AN8424D	Elbow		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)		
		Elbow	<u>M16139</u>	<u>9/5/21</u>
		Batch:		<u>SCD</u>
3.0	41232 200 007 001	Brass Cylinder Assembly		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)		
		Brass Cylinder Assembly	<u>43733</u>	<u>9/5/21</u>
		Batch:		<u>SCD</u>
4.0	MS1699623	cap screw		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)		
		cap screw	<u>M103934</u>	<u>9/5/21</u>
		Batch:		<u>SCD</u>
5.0	AN3154R	Nut		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)		
		Nut	<u>M17566</u>	<u>9/5/21</u>
		Batch:		<u>SCD</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LH ACTUATOR ASSEBLY

Job Number: 43569

Part Number: 41232 200 001 001

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M111279

9/5/21

SP

7.0 AN960JD10

Washer



SP

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M111279

9/5/21

8.0 MS21042L3

Nut



9/5/21

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M111279

M110844

SP

9.0 AN322A

Bolt



9/5/21

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M106043

M110844

SP

10.0 41232 200 005 003

Spacer (Step Actuator)



9/5/21

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer (Step Actuator)

Batch: 1539218

9/5/21

SP

11.0 41232 200 002 005

pivot arm



9/5/21

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

pivot arm

Batch: A46101

9/5/21

SP

12.0 41232 200 002 003

latch



9/5/21

SP

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

latch

Batch: 46703

9/5/21

SP

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: LH ACTUATOR ASSEBLY

Job Number: 43569

Part Number: 41232 200 001 001

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 41232 200 002 001

tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

tube

Batch:

43303

9/1/11

SD

14.0 41232 200 008 001

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Decal

Batch:

43303

B46687

9/1/11

1/8/12

24

15.0 S 1455

spring-step actuator (replaces 71459)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

spring-step actuator (replaces 71459)

BATCH:

71459

9/1/11

26

16.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg 41232-200-001

2-Torque as per Dwg 41232-200-001

FF 09-06-15

2

17.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/09/06/05

6244

24

18.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9/1/11

54

19.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/16

MF 09-06-16

Job Completion



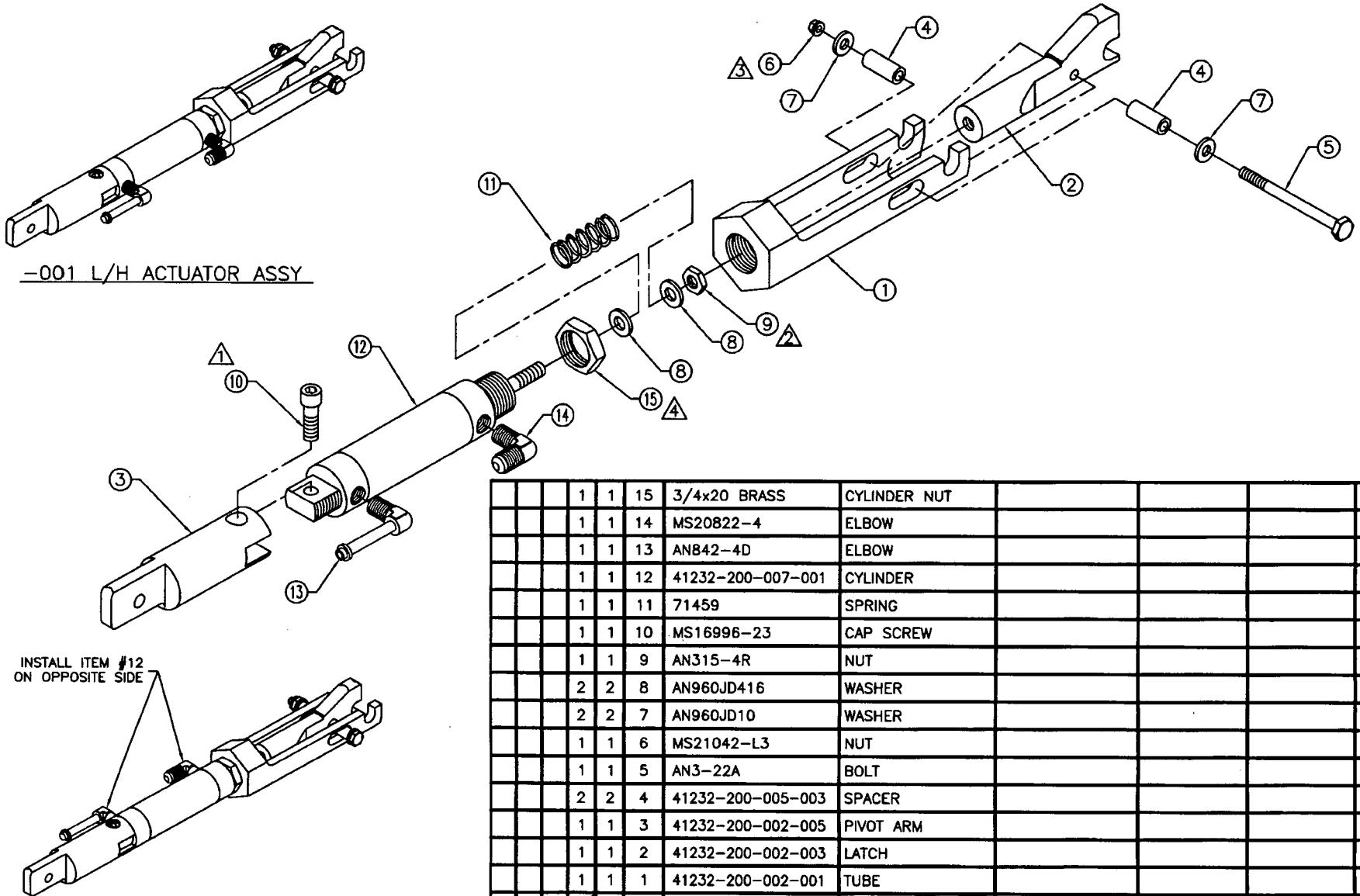
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



-002 R/H ACTUATOR ASSY

- ▲ TORQUE 80-100 IN.-LB.
- ▲ TORQUE 20-25 IN.-LB.
- ▲ TORQUE 50-75 IN.-LB.
- ▲ TORQUE 50-75 IN.-LB.

**NOTES:**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
100-13250

1	1	15	3/4x20 BRASS	CYLINDER NUT			
1	1	14	MS20822-4	ELBOW			
1	1	13	AN842-4D	ELBOW			
1	1	12	41232-200-007-001	CYLINDER			
1	1	11	71459	SPRING			
1	1	10	MS16996-23	CAP SCREW			
1	1	9	AN315-4R	NUT			
2	2	8	AN960JD416	WASHER			
2	2	7	AN960JD10	WASHER			
1	1	6	MS21042-L3	NUT			
1	1	5	AN3-22A	BOLT			
2	2	4	41232-200-005-003	SPACER			
1	1	3	41232-200-002-005	PIVOT ARM			
1	1	2	41232-200-002-003	LATCH			
1	1	1	41232-200-002-001	TUBE			
		-002		R/H ACTUATOR ASSY			
		-001		L/H ACTUATOR ASSY			
-002	-001	IND. NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL.SPEC
NO. REQ'D PER ASSY				LIST OF MATERIAL			ZONE

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